

[Document Name] Claims

[Claim 1] A method of manufacturing a full face vehicle wheel including: a wheel rim with one opening brim thereof formed to be a flange portion while the other opening brim to be a peripheral joining end; and a wheel disk with the periphery thereof formed to be a flange portion for supporting a tire bead sidewise, with said peripheral joining end welded to the back surface of said wheel disk, characterized in that:

the back surface of the wheel disk is provided in advance with an annular joining groove; the peripheral joining end of the wheel rim is provided in advance with an inside slope end surface; said peripheral joining end is seated and positioned on the bottom surface of the annular joining groove; in which state, a welding heat confining annular region is produced between the inside groove wall of the annular joining groove and the inside slope end surface by placing the inside edge of the inside slope end surface in contact with or near said inside groove wall; and the annular joining groove and the peripheral joining end are joined by welding, so that the wheel disk and the wheel rim are joined.

[Claim 2] The method of manufacturing the full face vehicle wheel of Claim 1, wherein the inside slope end surface formed at the peripheral joining end of the wheel rim has a slope angle within a range greater than about three degrees and not greater than about 60 degrees relative to the bottom surface of the annular joining groove.

[Claim 3] The method of manufacturing full face vehicle wheel of Claim 1 or 2, wherein the inside slope end surface of the peripheral joining end of the wheel rim is formed by bending the opening brim where said peripheral joining end is formed toward the inside of the wheel rim.

[Claim 4] The method of manufacturing the full face vehicle

wheel of any one of Claims 1 to 3, wherein the outside groove wall of the annular joining groove is formed to tilt outward by an angle within a range greater than about 40 degrees and not greater than about 90 degrees relative to the bottom surface of the annular joining groove.